



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-3

Job Sheet 175107

Part No: D4776-3

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Job Created: 3/27/18

Due Date: 4/27/18

Type: Steel

Job Qty: 30 ea

Status: Scheduled

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Description:

Priority: Medium

Note: DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	4/25/18	4/25/18	0.00	0.00	Start Up Machining-3	2ml	DAS
100	Bandsaw	30 pcs	4/25/18	4/25/18	0.00	0.54	Bandsaw1	"	54
110	CNC Vertical Machining	30 pcs	4/26/18	4/26/18	0.26	26.09	HAAS1-5	"	9-89
120	QC	30 pcs	4/26/18	4/26/18	0.00	0.00	QC2 Machining-3	"	
130	QC	30 pcs	4/26/18	4/26/18	0.00	0.00	QC8 Machining-3		
140	HandFinish	30 pcs	4/26/18	4/26/18	0.00	0.79	HandFinish1		
150	QC	30 pcs	4/26/18	4/26/18	0.00	0.00	QC7-4		
160	Powdercoat	30 pcs	4/27/18	4/27/18	0.00	0.37	Powdercoat1		
170	QC	30 pcs	4/27/18	4/27/18	0.00	0.00	QC3		
180	Packaging	30 pcs	4/27/18	4/27/18	0.00	0.00	Packaging3-2	5/115	
190	QC21-SA	30 Ea	4/27/18	4/27/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME: 11:20

DU.T. 320 FINISH: 12:20 M138760.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X02.500	6061-T6 Bar 1.50 X 2.50	11.0100 ft (.367 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X02.500	11	52	0

DART
AEROSPACE

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CANADA
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Container No: S069628



Part: D4776-3

Job No: 175107

Serial No/Batch: S069628

Revision:

Inspector:

Date: 05/09/18

240
A2
82-8

240
A2
82-8

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches $\pm$ 0.030	4.280 4.220		4.249
2	Skidtube Clevis	2.250Inches $\pm$ 0.030	2.280 2.220		2.247
3	Skidtube Clevis	1.688Inches $\pm$ 0.010	1.698 1.678		1.685
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		0.875
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510		0.515
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053		1.063
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350		1.038
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		0.188
9	Skidtube Clevis	1.000Inches $\pm$ 0.030	1.030 0.970		1.001
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	Diameter	0.487
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		0.495
12	Skidtube Clevis	0.550Inches $\pm$ 0.030	0.580 0.520		0.547
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140		3.149
14	Skidtube Clevis	1.130Inches $\pm$ 0.030	1.160 1.100		1.127
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678		.690
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	Diameter	0.398
17	Skidtube Clevis	1.813Inches $\pm$ 0.010	1.823 1.803		1.811
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius	.190
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	.130
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius	.440
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115		0.124
22	Skidtube Clevis	0.380Inches $\pm$ 0.030	0.410 0.350		.380
23	Skidtube Clevis	0.750Inches $\pm$ 0.030	0.780 0.720		.750
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	.250

Plex 3/28/18 11:10 AM Dart.Gagnon.Michelle